

Date: Tuesday, 1/3/2006 4:19:15 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 0H-58 SKIDTUBE ASSEMBLY
Job Number	: 25369		
Estimate Number	: 10475		
P.O. Number	: N/A	Part Number	: D058672041
This Issue	: 1/3/2006 S.O. No. : N/A	Drawing Number	: D2922 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: A1
Previous Run	: 25368	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 1/30/2006 Qty: 1 Um: Each
Checked & Approved By	: <u>SEE ABOVE USER & DATE</u>		
Comment	: Est Rev:C 02.06.28 Re-format; ECN 258 KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2620	Bent 206 Skidtube
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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1	D2620	Bent Tube 3" OD	B24497 DP06-2-3 ①
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2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube DP06-2-3 ①

2-Cut aft end of D2620 bent tube as per dwg D2922 DP06-2-3 ①

3-Drill pilot holes using drill jig DT 8480 open to 0.312" dia. DP06-2-6 ①

4-Drill holes for wearplates using DT 8487 Open to 0.297" dia. DP06-2-6 ①

5-Drill holes for aft cap as per Dwg D2922 using drill jig DT 8025. Open using #6 Drill Bit DP06-2-6 ①

6-Open CHW holes to 0.500 per dwg D2922

7-Remove inner indexing ridge on aft end of skidtube as per Dwg D2922 DP06-2-6-①

8-Deburr and Blow out all chips form inside the tube DP06-2-6-①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Machine Or Operation:

Description :

3.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m 06-02-07 ①

4.0

D2923

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2923

Web

B25392

Pm 06-02-08 ①

5.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2922(without cutting fluid)

Pm 06-02-08 ①

2-Countersink crossbolt spacer holes as per Dwg D2922(without cutting fluid)

Pm 06-02-08 ①

3-Deburr and Blow out all chips from inside the tube

Pm 06-02-08 ①

4-Bond D2923 web in place as per QSI 015. Ensure holes lineup

Pm 06-02-08 ①

A/R

Sikaflex-291

m19591

Sikaflex expire date: *06-06-28*

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

D2794

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Qty

Part Number

Description

Batch

1 D2794

Fwd Cap

B14400 BE 06-02-07 ①

8.0

D2649

Crossbolt Spacer



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

22 D2649

Crossbolt spacer

B24200 BE 06-02-09 ①

W/O:		WORK ORDER CHANGES					
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Job Number: 25369

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description:

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld D2794 cap as per QSI 004 and Dwg D2922. Use aluminum rod.

A/R Aluminum Rod

M15855 / M19100 BE 06-02-07 (1)

2-Weld D2649 cross bolt spacers as per QSI 004 and Dwg D2922. (Remember to back drill each hole to 0.250" before welding the other side)

A/R Aluminum Rod

M18839 BE 06-02-09 (1)

3-Grind welds flush as per Dwg D2922

DP 06-2-10 (1)

4-Counterbore 5/16" x 0.750" deep as per Dwg D2922

Pm 06-02-15 (1)

10.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

John 06-02-10

PD 06-02-15

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-03-01

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 06 03 07

13.0

D26483

Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

5 D2648-3 Wearpad *624843*

FL

14.0

D265615

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2656-15 Wearshoe *621712*

FL 06 03 07

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QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Tuesday, 1/3/2006 4:19:16 PM
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Process Sheet

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Drawing Name: 0H-58 SKIDTUBE ASSEMBLY

Job Number: 25369

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

D265621

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D2656-21 Wearshoe

Batch

B20532

FC

16.0

D2924

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D2924 Wearshoe

Batch

B12445

FC

17.0

MS27039108

Screw



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number Description

50 MS27039-1-08 Screw

Batch

M16941

FC

18.0

AN960JD10L

Washer



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number Description

50 AN960JD10L Washer

Batch

M19185

FC

19.0

ALS41032130

Insert



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number Description

50 ALS4-1032-130 Insert

Batch

M1576

or (see QSI 017)

ALS41032-225

FC 06 03 07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 25369

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D26511

Plug



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number Description Batch
20 D2651-1 Plugs D25010

FC

21.0

D26513

O-Ring



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number Description Batch
20 D2651-3 O-Rings D23491

FC

22.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2646 Aft Cap D20208

FC

23.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 MS27039-1-08 Screw M16941

FC

24.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 AN960JD10L Washer M19185

FC 06 03 07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DP Date: 06/03/13
 QA: N/C Closed: _____ Date: _____

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Drawing Name: 0H-58 SKIDTUBE ASSEMBLY

Job Number: 25369

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Insert a drop of Sikaflex at insert hole before installing wearplates. *FC*

A/R Sikaflex-291 *m/19597*

Sikaflex expire date: *06 18 06*

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2922 *FC*

3-Install D2646 Aft Cap and seal with Sikaflex adhesive. Clean excess adhesive *FC* *06 03 07*

A/R Sikaflex-291 *m/19597*

Sikaflex expire date: *06 18 06*

3- Wing Walk as per Dwg D2922 and QSI 005 4.4

m/10037

FC *06 03 08* Batch:

26.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

m/ *06 03 08* *(1)*

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *CY 06/03/08* *(1)*

28.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D *06/03/13* *(1)*

Job Completion



n *06-03-07*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2922	REV. A SHEET 1 OF 2
DATE 99.10.14		TITLE OH-58 SKIDTUBE ASSEMBLY	SCALE NTS
A	99.10.14	NEW ISSUE	
AI	01.08.20	Ø0.640 WAS Ø0.625	

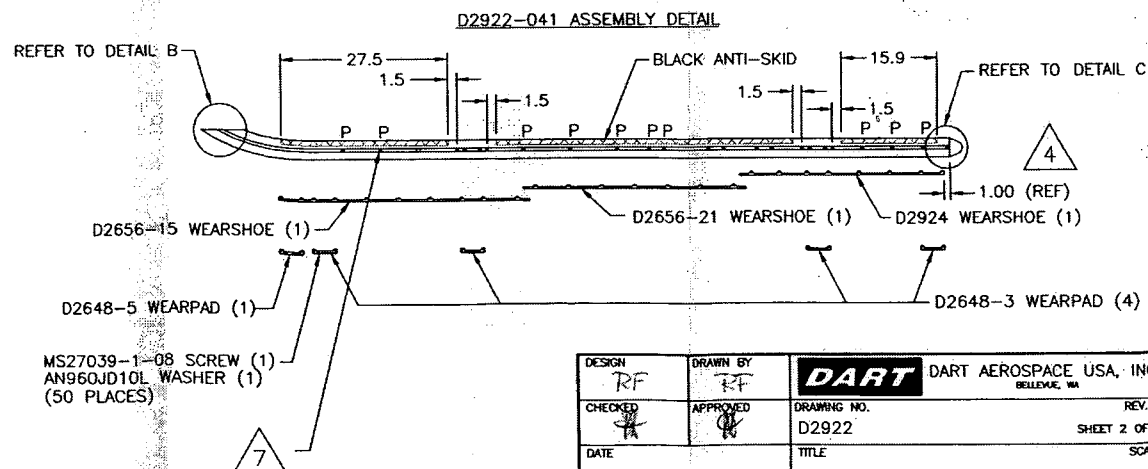
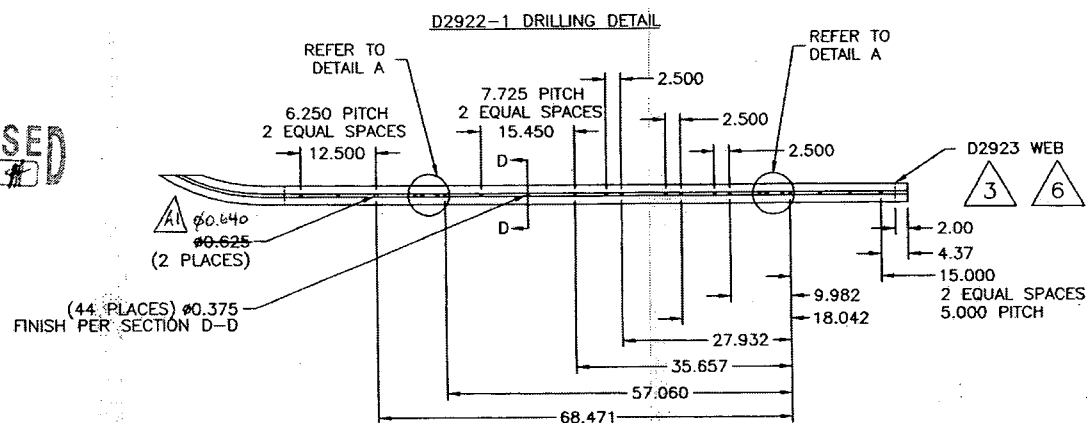
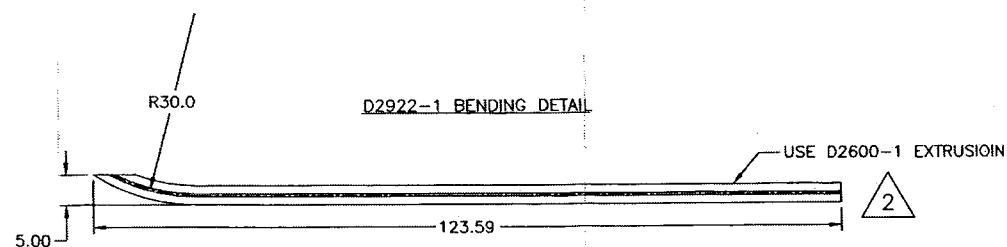
RELEASED
00.05.11 [Signature]

Qty	Part Number	Description
X	D2922-041	SKIDTUBE ASSEMBLY
*	D2600-1	EXTRUSION
1	D2646	AFT CAP
4	D2648-3	WEARPAD
1	D2648-5	WEARPAD
22	D2649	CROSS BOLT SPACER
20	D2651-1	PLUG
20	D2651-3	O-RING
1	D2656-15	WEARSHOE
1	D2656-21	WEARSHOE
1	D2794	CAP
1	D2923	WEB
1	D2924	WEARSHOE
50	AKS7-1032-130 or AKS4-1032-130 or ALS7-1032-130 or ALS4-1032-130	INSERT
52	AN960JD10L	WASHER
52	MS27039-1-08	SCREW

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2600-1 EXTRUSION REQUIRED BEFORE BENDING = 160 INCHES.*
- 3) INSERT D2923 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI-015 AFTER BENDING.
- 4) USE DART DRILL TEMPLATE DT8406 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL AKS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL MS27039-1-08 SCREWS AND AN960JD10L WASHERS IN ALL INSERTS. SEAL WITH SIKAFLEX-241/291.
- 5) WELDING TO BE DONE PER DART QSI 004.
- 6) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2923 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 0.50 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 7) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (20 PLACES).

ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 25369



DESIGN RF	DRAWN BY RF	 DART AEROSPACE USA, INC. BELLVILLE, WA
CHECKED JA	APPROVED CV	
DRAWING NO. D2922		REV. 1 SHEET 2 OF 2
DATE 99.10.14	TITLE OH-58 SKIDTUBE ASSEMBLY SCALE 1:21	

